

Work Order ID 116266

May-26-14 8:39:36 AM

Report

116266

Page 1

Item ID: D4417-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/11/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2690

B2

D4417

B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

SL

14/05/26 *(4)*

DAS
32
9-89

120

0.00

120

HandFinish

Hand Finishing

Memo

0.00

- 1- ASSEMBLE AS PER DWG
- 2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240 CABLE AND CRIMP CBL-460 AS PER DWG D2690

4x d *14/05/27*

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Item ID: D4417-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Q.R. Step Assembly (206L/407)
 Start Date: 4/11/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/11/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 14/5/27				4			
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 JRP MAY 28 2014 116767			DAS 06 9-89	4			
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MCS	14-05-28		MF 14-5-28

Picklist Print

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Work Order ID: 116266

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Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/11/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP
REV:B 11.08.17 PER REV.B DD VERF:JLM IPP REV:C
11.10.25 replace D2690-6 for CBL-460 & CBL-1240 for assembling purpose
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240 *CBI -1240* Cable		Purchased	No			120	f	410.4000	0.708	3			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				410.4					
				m128229				410.4					
CBL-460 *CBI -460* Loop Sleeve		Purchased	No			120	Each	136.0000	2	8			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				136					
				125499				5					
				m127811				3					
				m128229				5					
				m129007				123					
D4417-041 *D4417-041* Step Assembly		Manufactured	No			120	Each	0.0000	1	4			
**													
D4418-1 *D4418-1* Step Lug		Manufactured	No			120	Each	0.0000	2	8			
**													

ll 11/05/27

✓ 3

ll 11/05/27

✓ 8

B 112522 (v4) ll 11/05/27

B 119148 (v8) ll 11/05/27

Picklist Print

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Work Order ID: 116266

116266

Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/11/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

D2570

Manufactured No

120 Each

566.0000 4 16

DAS
32
9-89

D2570

Bushing

Location

Loc Qty

Loc Code

FG

12

88781

12

ST011

554

108538

37

112726

5

113679

12

115735

200

117844

300

108538

DAS
32
9-89

AN4C16A

Purchased No

120 Each

82.0000 2 8

AN4C16A

BOLT

Location

Loc Qty

Loc Code

ST357

42

m128179

42

ST517a

40

122800

20

m126474

20

m128179

AN4C36A

Purchased No

120 Each

20.0000 2 8

AN4C36A

Bolt

DAS
32
9-89

14/5/26 (4)

Location

Loc Qty

Loc Code

ST358

20

118518

20

118518

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Work Order ID: 116266

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Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/11/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

MS17984-C415

Purchased

No

120

Each

14.0000

2

8

DAS

32

9-89

MS17984-C415

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST332

14

123482

1

124020

1

125049

4

m128893

8

m124020 1x

m128893 7x

MS21043-4

Purchased

No

120

Each

3,944.000

4

16

DAS

32

9-89

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST315

171

125654

26

m128429

145

ST509

3733

m127255

13

m128300

720

m128798

1500

m128818

1500

m128429

D4428-1

Manufactured

No

120

Each

15.0000

2

8

DAS

32

9-89

D4428-1

Bushing

Location

Loc Qty

Loc Code

ST106

15

112174

15

14/5/26 (4)

112174

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Picklist Print

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Work Order ID: 116266

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

116266

D4417-011

Start Date: 4/11/14

Required Date: 4/11/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

120

Each

3,586.000

8

32

NAS1149C0432R

WASHER

DAS

32

989

Location

Loc Qty

Loc Code

GA

1525

m125807

1525

ST292

87

119124

6

121255

2

122441

79

ST510a

1974

m126221

1974

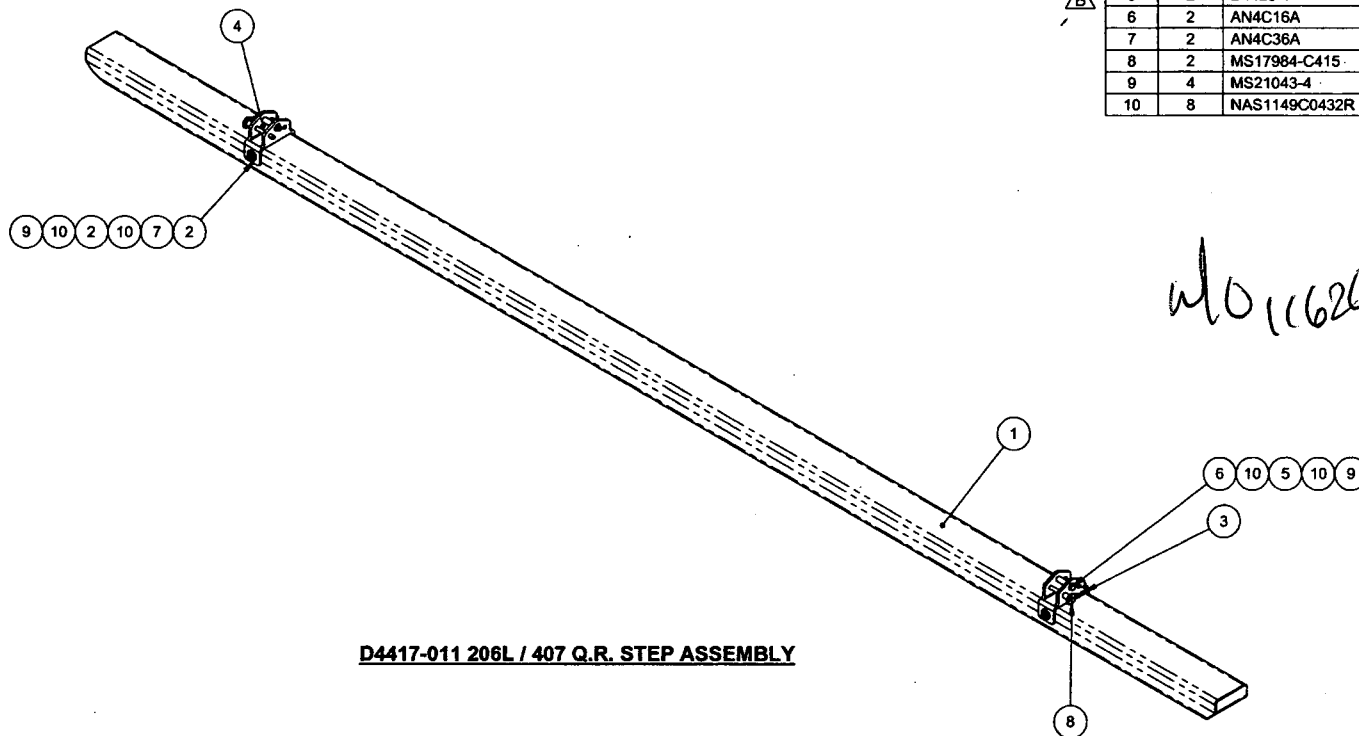
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14/07/26 (9)

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Shop Packet Print

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D4417-011 206L / 407 Q.R. STEP ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

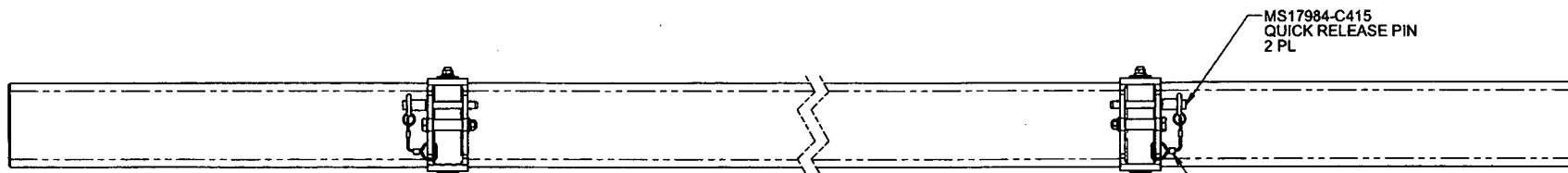
RELEASED
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4417 SHEET 1 OF 4 TITLE 206L / 407 Q.R. STEP ASSEMBLY SCALE NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.28	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

D



MS17984-C415
QUICK RELEASE PIN
2 PL

AN4C36A BOLT
NAS1149C0432R WASHER, 2X
D2570 BUSHING, 2X
MS21043-4 NUT
2 PL

D2690-6
LANYARD ASSEMBLY
2 PL

C

C

AN4C16A BOLT
NAS1149C0432R WASHER, 2X
D4428-1 BUSHING
MS21043-4 NUT
2 PL

D4418-1
STEP LUG
2 PL

D4417-041
STEP ASSEMBLY

B

B



6

D4417-011 206L / 407 Q.R. STEP ASSEMBLY

RELEASED
2011-08-02
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4417-011" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 8.75 lbs

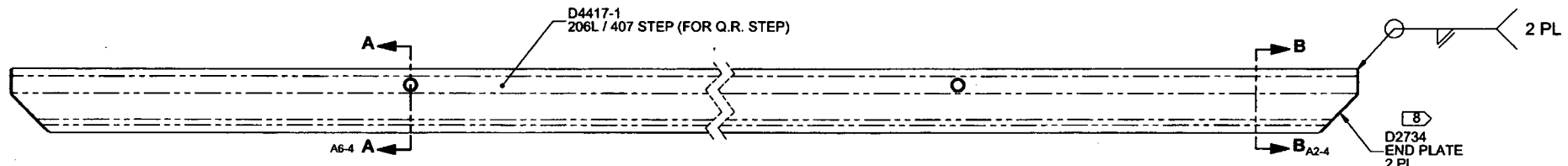
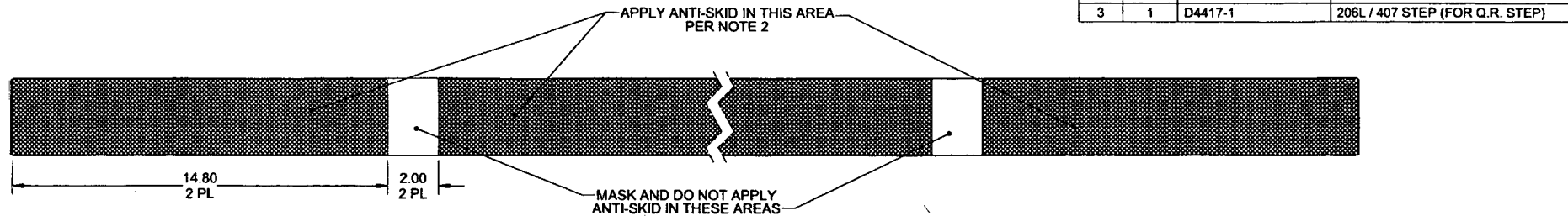
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A

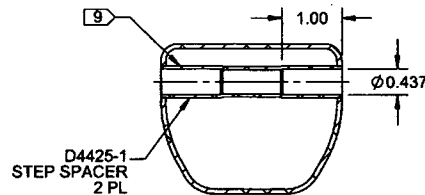
DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4417	REV. B SHEET 2 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	11.07.28		

8 7 6 5 4 3 2 1

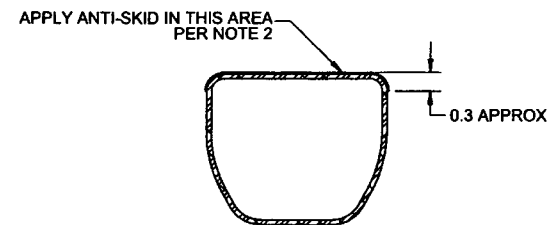
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



D4417-041 STEP ASSEMBLY



SECTION A-A C7-4
SCALE 2X



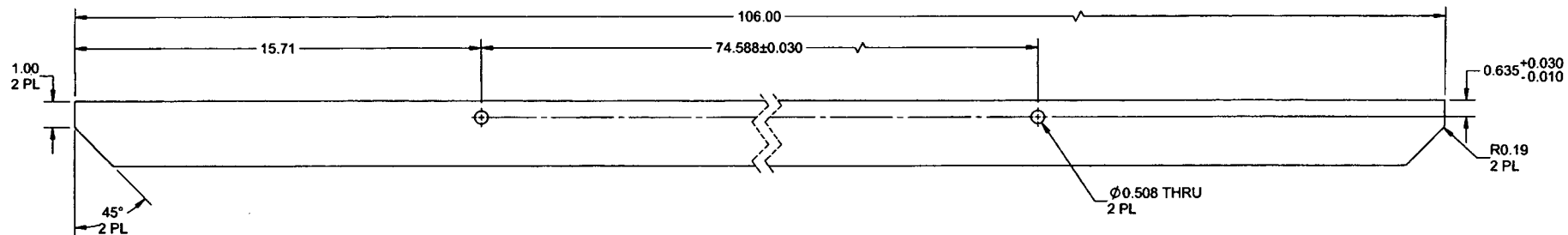
SECTION B-B C2-4
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED	A	D4417	SHEET 3 OF 4
MFG. APPR.	FE	TITLE	SCALE
APPROVED	MP	206L / 407 Q.R. STEP ASSEMBLY	NTS
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DATE	11.07.28		

RELEASED
2011-08-02
MP







D4417-1 206L / 407 STEP (FOR Q.R. STEP)

RELEASED
2011-08-02

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
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